



Designation: A 351/A 351M – 00

Used in USDOE-NE Standards

Standard Specification for Castings, Austenitic, Austenitic-Ferritic (Duplex), for Pressure-Containing Parts¹

This standard is issued under the fixed designation A 351/A 351M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This specification² covers austenitic and austenitic-ferritic (duplex) steel castings for valves, flanges, fittings, and other pressure-containing parts (Note 1).

NOTE 1—Carbon steel castings for pressure-containing parts are covered by Specification A 216/A 216M, and low-alloy steel castings by Specification A 217/A 217M.

1.2 A number of grades of austenitic and austenitic-ferritic steel castings are included in this specification. Since these grades possess varying degrees of suitability for service at high temperatures or in corrosive environments, it is the responsibility of the purchaser to determine which grade shall be furnished. Selection will depend on design and service conditions, mechanical properties, and high-temperature or corrosion-resistant characteristics, or both.

1.2.1 Because of thermal instability, Grades CE20N, CF3A, CF3MA, and CF8A are not recommended for service at temperatures above 800°F [425°C].

1.2.2 Because of embrittlement phases, Grade CD4MCu is not recommended for service at temperatures above 600°F [316°C].

1.3 The values stated in either inch-pound units or SI units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with the specification.

2. Referenced Documents

2.1 ASTM Standards:

¹ This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.18 on Castings.

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² For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-351/SA-351M in Section II of that code.

A 216/A 216M Specification for Steel Castings, Carbon, Suitable for Fusion Welding, for High-Temperature Service³

A 217/A 217M Specification for Steel Castings, Martensitic Stainless and Alloy, for Pressure-Containing Parts, Suitable for High-Temperature Service³

A 488/A 488M Practice for Steel Castings, Welding, Qualification of Procedures and Personnel³

A 703/A 703M Specification for Steel Castings, General Requirements, for Pressure-Containing Parts³

E 165 Test Method for Liquid Penetrant Examination⁴

E 709 Guide for Magnetic Particle Examination⁴

2.2 *Manufacturers Standardization Society of the Valve and Fittings Industry Standard:*

SP-55 Quality Standard for Steel Castings for Valves, Flanges, and Fittings and Other Components (Visual Method)⁵

3. General Conditions for Delivery

3.1 Material furnished to this specification shall conform to the requirements of Specification A 703/A 703M, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification A 703/A 703M constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification A 703/A 703M, this specification shall prevail.

3.2 The post weld heat treatment requirements of Supplementary Requirement S11 may be specified when austenitic castings other than HK, HT, or CT15C are to be subjected to severe corrosive service.

³ *Annual Book of ASTM Standards*, Vol 01.02.

⁴ *Annual Book of ASTM Standards*, Vol 03.03.

⁵ Available from Manufacturers' Standardization Society of the Valve and Fittings Industry, 1815 N. Fort Myer Drive, Arlington, VA 22209.



4. Ordering Information

4.1 The inquiry and order should include or indicate the following:

4.1.1 A description of the casting by pattern number or drawing (dimensional tolerances shall be included on the casting drawing),

4.1.2 Grade of steel,

4.1.3 Options in the specification, and

4.1.4 Supplementary requirements desired, including the standards of acceptance.

5. Process

5.1 The steel shall be made by the electric furnace process with or without separate refining such as argon-oxygen decarburization (AOD).

6. Heat Treatment

6.1 All castings shall receive a heat treatment at the temperature specified in Table 1, followed by a quench in water or rapid cool by other means except as noted.

NOTE 2—Proper heat treatment of these alloys is usually necessary to enhance corrosion resistance and in some cases to meet mechanical properties. Minimum heat-treat temperatures are specified; however, it is sometimes necessary to heat-treat at higher temperatures, hold for some minimum time at temperature and then rapidly cool the castings in order to enhance the corrosion resistance and meet mechanical properties.

7. Chemical Composition

7.1 The steel shall conform to the requirements as to chemical composition prescribed in Table 2.

TABLE 1 Heat-Treatment Requirements

Grade	Temperature, min	
	°F	°C
HK30, HK40, HT30, CT15C	as-cast	as-cast
CF3, CF3A, CF8, CF8A, CF3M, CF3MA, CF8M, CF3MN, CG3M, CF10, CF10M, CG8M, CD4MCu	1900	1040
CF10SMnN, CF8C, CF10MC	1950	1065
CD3MWCuN	2010	1100
CN7M, CG6MMN, CE8MN	2050	1120
CK3MCuN, CN3MN, CH8, CH10, CH20, CK20	2100	1150
CE20N ^A	2225	1220

^AGrade shall be quenched in water or the castings may be furnace cooled to 2050°F [1120°C] minimum, held for 15 min minimum and then quenched in water or rapidly cooled by other means.

8. Tensile Properties

8.1 Steel used for the castings shall conform to the requirements as to tensile properties prescribed in Table 3.

9. Quality

9.1 The surface of the casting shall be examined visually and shall be free of adhering sand, scale, cracks, and hot tears. Other surface discontinuities shall meet the visual acceptance standards specified in the order. Visual Method SP 55 or other visual standards may be used to define acceptable surface discontinuities and finish. Unacceptable visual surface discontinuities shall be removed and their removal verified by visual examination of the resultant cavities.

9.2 When additional inspection is desired, Supplementary Requirements S5, S6, and S10 may be ordered.

9.3 The castings shall not be peened, plugged, or impregnated to stop leaks.

10. Repair by Welding

10.1 Repairs shall be made using procedures and welders qualified under Practice A 488/A 488M.

10.2 Weld repairs shall be inspected to the same quality standards that are used to inspect the castings. When castings are produced with Supplementary Requirement S5 specified, weld repairs on castings that have leaked on hydrostatic test, or on castings in which the depth of any cavity prepared for repair welding exceeds 20 % of the wall thickness or 1 in. [25 mm], whichever is smaller, or on castings in which any cavity prepared for welding is greater than approximately 10 in.² [65 cm²], shall be radiographed to the same standards that are used to inspect the castings. When castings are produced with Supplementary Requirement S6 specified, weld repairs shall be inspected by liquid penetrant examination to the same standards that are used to inspect the castings.

NOTE 3—When austenitic steel castings are to be used in services where they will be subject to stress corrosion, the purchaser should so indicate in his order and such castings should be solution-heat treated following all weld repairs.

11. Keywords

11.1 austenitic stainless steel; duplex stainless steel; pressure containing parts; stainless steel; steel castings

TABLE 2 Chemical Requirements

NOTE 1—Tungsten is a new element for Table 2.

Element, % (max, except where range is given)	CF3, CF3A	CF8, CF8A	CF3M, CF-3MA	CF8M	CF3MN	CF8C	CF10	CF-10M (J92-901)	CH8	CH10	CH20	CK20	HK30	HK40	HT30	CF-10MC	CN7M	CN-3MN	CD-4MCu	CE8MN	CG-6MMN	CG8M	CF10S-MnN	CT15C	CK-3MCuN	CE20N	CG-3M (J92-999)	CD3M-WCuN ^A
Carbon	0.03	0.08	0.03	0.08	0.03	0.08	0.04–0.10	0.04–0.10	0.08	0.04–0.10	0.04–0.20	0.04–0.20	0.25–0.35	0.35–0.45	0.25–0.35	0.10	0.07	0.03 max	0.04	0.08	0.06	0.08	0.10	0.05–0.15	0.025	0.20	0.03	0.03
Manganese	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50	1.50	2.00	1.50	1.50	2.00 max	1.00	1.00	4.00–6.00	1.50	7.00–9.00	0.15–1.50	1.20	1.50	1.50	1.00
Silicon	2.00	2.00	1.50	1.50	1.50	2.00	2.00	1.50	1.50	2.00	2.00	1.75	1.75	1.75	2.50	1.50	1.50	1.00 max	1.00	1.50	1.00	1.50	3.50–4.50	0.50–1.50	1.00	1.50	1.50	1.00
Sulfur	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.010 max	0.04	0.040	0.030	0.04	0.030	0.03	0.010	0.040	0.04	0.025
Phosphorus	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.040 max	0.04	0.040	0.040	0.04	0.060	0.03	0.045	0.040	0.04	0.030
Chromium	17.0–21.0	18.0–21.0	17.0–21.0	18.0–21.0	17.0–21.0	18.0–21.0	18.0–21.0	18.0–21.0	22.0–26.0	22.0–26.0	22.0–26.0	23.0–27.0	23.0–27.0	23.0–27.0	13.0–17.0	15.0–18.0	19.0–22.0	20.0–22.0	24.5–26.5	22.5–25.5	20.50–23.50	18.0–21.0	16.0–18.0	19.0–21.0	19.5–20.5	23.0–26.0	18.0–21.0	24.0–26.0
Nickel	8.0–12.0	8.0–11.0	9.0–13.0	9.0–12.0	9.0–13.0	9.0–12.0	8.0–11.0	9.0–12.0	12.0–15.0	12.0–15.0	12.0–15.0	19.0–22.0	19.0–22.0	19.0–22.0	33.0–37.0	13.0–16.0	27.5–30.5	23.5–25.5	4.75–6.00	8.0–11.0	11.50–13.50	9.0–13.0	8.0–9.0	31.0–34.0	17.5–19.5	8.0–11.0	9.0–13.0	6.5–8.5
Molybdenum	0.50	0.50	2.0–3.0	2.0–3.0	2.0–3.0	0.50	0.50	2.0–3.0	0.50	0.50	0.50	0.50	0.50	0.50	0.50	1.75–2.25	2.0–3.0	6.0–7.0	1.75–2.25	3.0–4.5	1.50–3.00	3.0–4.0	6.0–7.0	0.50	3.0–4.0	3.0–4.0
Columbium (niobium)	^B	^C	0.10–0.30	0.50–1.50
Vanadium	0.10–0.30
Nitrogen	0.10–0.20	0.18–0.26	...	0.10–0.30	0.20–0.40	...	0.08–0.18	...	0.18–0.24	0.08–0.20	...	0.20–0.30
Copper	3.0–4.0	0.75 max	2.75–3.25	0.50–1.00	0.5–1.0
Tungsten	0.5–1.0
Iron	Bal

^A % Cr + 3.3 % Mo + 16 % N ≥ 40.

^B Grade CF8C shall have a columbium content of not less than 8 times the carbon content but not over 1.00 %.

^C Grade CF10MC shall have a columbium content of not less than 10 times the carbon content but not over 1.20 %.



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TABLE 3 Tensile Requirements

	CF3	CF-3A	CF8	CF-8A	CF-3M	CF-3MA	CF-8M	CF-3MN	CF-8C	CF-10	CF-10M (J92-901)	CH8	CH10	CH20	CK20	HK30	HK40	HT30	CF-10MC	CN-7M	CN-3MN	CD-4MCu	CE-8MN	CG-6M-MN	CG-8M	CF10S-MnN	CT-15C	CK-3M-CuN	CE20N	CG-3M (J92-999)	CD3M-WCuN
Tensile strength, ^A min, ksi [MPa]	70 [485]	70 [485]	77 [530]	77 [530]	70 [485]	80 [550]	70 [485]	75 [515]	70 [485]	70 [485]	70 [485]	65 [450]	70 [485]	70 [485]	65 [450]	65 [450]	62 [425]	65 [450]	70 [485]	62 [425]	80 [550]	100 [690]	95 [655]	85 [585]	75 [515]	85 [585]	63 [435]	80 [550]	80 [550]	75 [515]	100 [700]
Yield strength, ^A min, ksi [MPa]	30 [205]	30 [205]	35 [240]	35 [240]	30 [205]	37 [255]	30 [205]	37 [255]	30 [205]	30 [205]	30 [205]	28 [195]	30 [205]	30 [205]	28 [195]	35 [240]	35 [240]	28 [195]	30 [205]	25 [170]	38 [260]	70 [485]	65 [450]	42.5 [295]	35 [240]	25 [170]	25 [170]	38 [260]	40 [275]	35 [240]	65 [450]
Elongation in 2 in. or 50 mm, ^B min, %	35.0	35.0	35.0	35.0	30.0	30.0	30.0	30.0	30.0	30.0	30.0	30.0	30.0	30.0	30.0	10.0	10.0	15.0	20.0	35.0	35.0	16.0	25.0	30.0	25.0	30.0	20.0	35.0	30.0	25.0	25.0
Reduction of area, min, %

^A Determine by the 0.2 % offset method.

^B When IC1 test bars are used in tensile testing as provided for in Specification A 703/A 703M, the gage length to reduced section diameter ratio shall be 4 to 1.



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SUPPLEMENTARY REQUIREMENTS

The following supplementary requirements shall not apply unless specified in the purchase order. A list of standardized supplementary requirements for use at the option of the purchaser is included in Specification A 703/A 703M. Those which are ordinarily considered suitable for use with this specification are given below. Others enumerated in Specification A 703/A 703M may be used with this specification upon agreement between the manufacturer and purchaser.

S2. Destruction Tests

S5. Radiographic Inspection

S6. Liquid Penetrant Inspection

S10. Examination of Weld Preparation

S10.1 The method of performing the magnetic particle or liquid penetrant test shall be in accordance with Practice E 165 or Practice E 709.

S11. Post Weld Heat Treatment

S11.1 All austenitic castings, except Grades HK, HT, and CT15C, which have been subjected to weld repairs, shall be given a post weld solution heat treatment.

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